

Work Order ID 65962 *glt 2*

Friday, January 28, 2011 11:39:51 AM



Page 1

Item ID: D4148-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Stop



Start Date: 1/28/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: *unp*

Date: 11-01-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4148

Prog Rev: *C*

Dwg Rev: *C*

Deburr as required

FBH-28

11/22/02

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FBH-28

11/22/02

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Page 2

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Item Name: Crosstube Lug Plate, Fwd

Start Date: 1/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5/10/12



150



Packaging

Packaging

Identify as per dwg & Stock Location: 132

0.00

Memo

0.00



160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/03

mc

11-02-02

Picklist Print

Friday, January 28, 2011 11:39:45 AM

Page 1

Work Order ID: 65962

Parent Item: D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd



Start Date: 1/28/2011



Required Date: 1/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.10.29 as per revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	62.7000	0.3607	3.796842	3.8		
												1811-1-28	

Location

MAT

116623

Loc Qty

62.7

62.7

Loc Code

116623

10

DART AEROSPACE LTD		Work Order: 65962
Description: Fwd Crosstube Lug Plate		Part Number: D4148-1
Inspection Dwg: D4148	Rev: B <i>11.02.01</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	x		V IB 62	
Ø0.191	+0.005/-0.001	.192	x		V	
Ø0.38	+0.006/-0.001	.377	x		V	
Ø0.257	+0.006/-0.001	.258	x		V	
Ø0.50	+0.008/-0.001	.499	x		V	
0.94	+/-0.030	.94	x		V	
4.47	+/-0.030	4.469	x		V	
0.750	+/-0.010	.754	x		V	
8.47	+/-0.030	8.465	x		V	
8.096	+/-0.010	8.100	x		PRO WT	
5.43	+/-0.030	5.420	x		V	
5.197	+/-0.010	5.200	x		V	
4.733	+/-0.010	4.731	x		V	
0.310	+/-0.010	.303	x		V	
0.750	+/-0.010	.744	x		V	
0.375	+/-0.010	.382	x		V	
1.84	+/-0.030	1.836	x		V	
0.92	+/-0.030	.910	x		V	
3.000	+/-0.010	2.997	x		V	
0.750	+/-0.010	.743	x		V	
0.625	+/-0.010	.625	x		V	
1.982	+/-0.010	1.980	x		V	
0.991	+/-0.010	.998	x		V	
0.77	+/-0.030	.768	x		V	
1.54	+/-0.030	1.543	x		V	
2.47	+/-0.030	2.468	x		V	
0.82	+/-0.030	.822	x		V	
3.57	+/-0.030	3.575	x		V	
1.23	+/-0.030	1.232	x		V	
0.73	+/-0.030	.735	x		V	
0.125	+/-0.010	.116	x		V	

Measured by: IB	Audited by: S	Preliminary Approval:
Date: 11-1-78	Date: 11/02/02	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

